

# STAKING PROCEDURE

## REMOVAL OF THE STAKE IN THE LOWER BEARING.

To disassemble the staked lower bearing from the jack body, the following steps are to be carefully followed

1. Drill out the punched stake and the deformed thread with a  $1/16$ " dia. drill to a depth of about  $3/32$ " in one shot (see Fig. 4). In case it is required to drill more than once, re-drilling deeper will possibly rotate the lower bearing. Care must be taken so that it does not rotate.
2. Complete stake removal should facilitate easy removal of the lower bearing. Remove the lower bearing and proceed servicing as required.

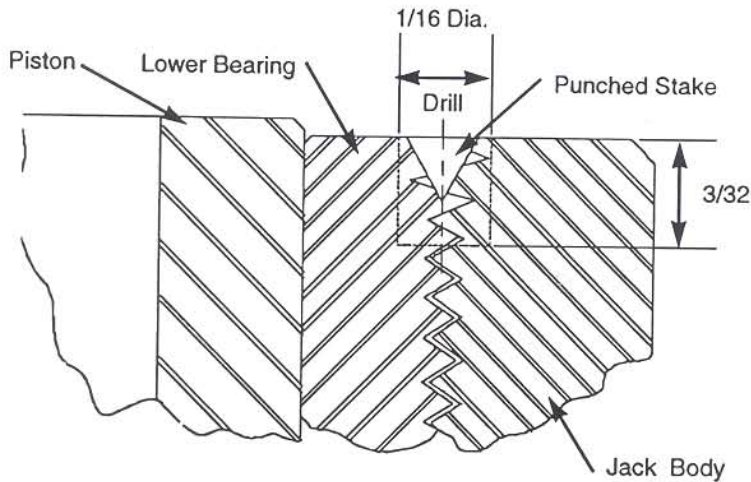


Figure 4

## RE-STAKING THE LOWER BEARING.

In order to re-stake after the jack body has been fully serviced, the following steps are to be followed,

1. Thread in the lower bearing into the jack body.
2. After tightening the nut completely, the original drill outs may not align together.
3. A new punched stake will be required. This may be located in any other spot at the mating threads (see Fig. 5). Use a 60° punch and stake so that depth does not exceed  $3/64$ ". Re-staking must be done after the jack body is assembled.

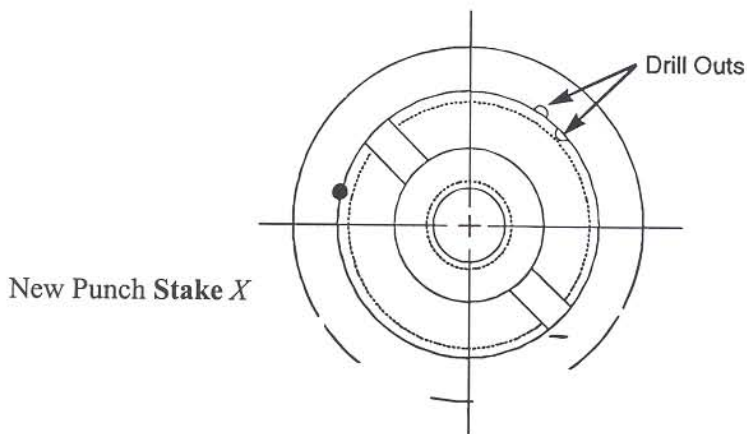


Figure 5